

Date: Wednesday, 1/31/2007 2:19:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHIM
Job Number : 30564	
Estimate Number : 10915	
P.O. Number : <u>N/A</u>	Part Number : D34421
This Issue : 1/31/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3442 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 28322	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 2/10/2007 Qty: 60 Um: Each
Checked & Approved By : <u>[Signature] 07.02.01</u>	
Comment : Est. A 05.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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1040

240



Comment: Qty.: 0 sf(s)/Unit Total : 2 sf(s)

304/316 .032 Sheet

Batch: M102159

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3442

Dwg Rev: AProg Rev: A SAD 07/02/04 60

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/04 (60)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M 07/02/06 (60)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Deburr if necessary.

M 07/02/07 x60

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/09	2.0	9 pieces were lost in basin of the water-jet because the tabs were not big enough	 051042	Lost in basin w-j Replace	SAD 07/02/09	 07/02/05	 051042	 07/02/05

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 30564

Part Number: D34421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



For 2-08



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS-baskets*

For 2-08

counted 61

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(H)

Comment: FINAL INSPECTION/W/O RELEASE

Revised 2/12

Job Completion



U 07-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

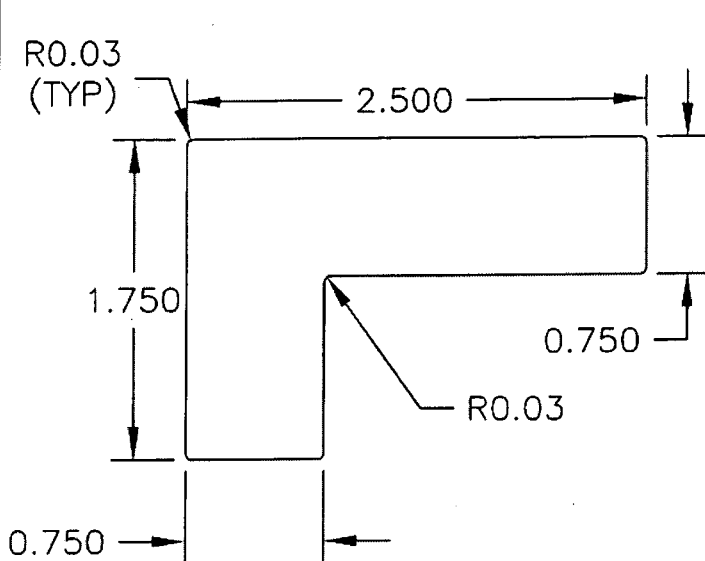
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

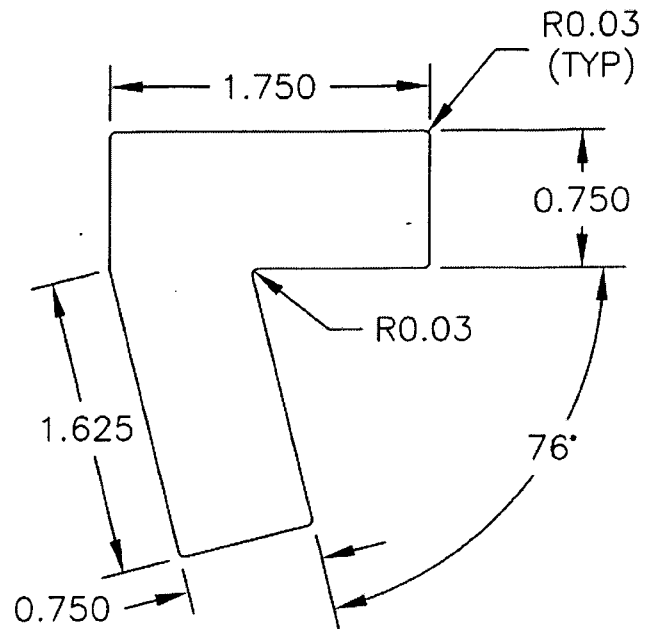
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03	TITLE SHIM		SCALE 1:1
A	05.06.03	NEW ISSUE	



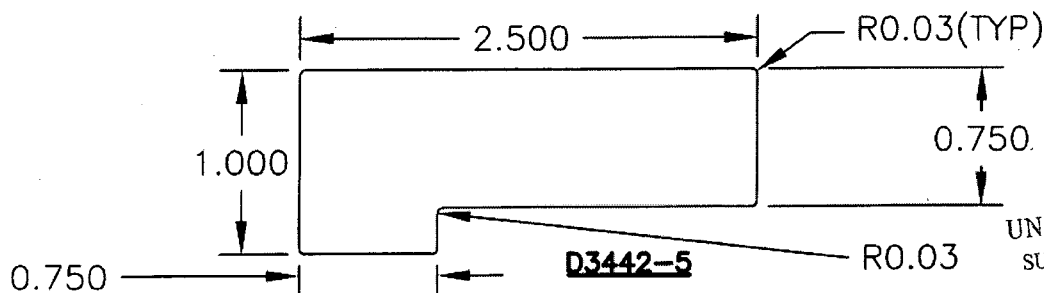
D3442-1



D3442-3

D3442-1/-3 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3442-5

D3442-5 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30564

RELEASED

05.08.19 [Signature]

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